

Work Order ID 51641

August 27, 2009 8:28:34 AM



Page 1

Item ID: D3536-37

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gasket

Start Date: 8/27/09 Start Qty: 5.00



Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan:

[Signature]

Date: 07-8-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 1 Dwg Rev: A 1 Prog Rev: A 1 2-
Deburr if necessary

B 9-9-9

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-9-9

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 502/02/07

13

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51641

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Page 2

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Item Name: Gasket

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Start Qty: 5.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: FINISH 0.00



Packaging

Memo

0.00

Packaging

09/09/10 (13)

140

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

09/09/10
MF 09-09-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:28:33 AM

Page 1

Work Order ID: 51641

Parent Item: D3536-37RevA

Parent Item Name: Gasket

Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	638.9541	3.9653	9.5167		



NEOPRENE SHEET 0.063



HB 999

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

638.9540585

111469

71.1

111853

167.854059

112508

400

NONE

NONE

112508

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	51641
Description: GASKET		Part Number:	D3536-37
Inspection Dwg: D3536-37 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
30 X .30	+/- .030	30.1 X .308	*			
Ø .19	+ .005 - .001	.193	*			
1.89	+/- .030	1.893	*			
6.00	+/- .030	6.000	*			
8.00	+/- .030	8.000	*			
16.00	+/- .030	16.000	*			
21.00	+/- .030	21.000	*			
2.00	+/- .030	2.000	*			
4.75	+/- .030	4.75	*			
9.50	+/- .030	9.50	*			
14.25	+/- .030	14.25	*			
17.75	+/- .030	17.75	*			
22.50	+/- .030	22.50	*			
27.25	+/- .030	27.25	*			
30.75	+/- .030	30.75	*			
.063	+/- .010	.065	*			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9/9/09	Date: 05/07/09	Date:	N/A

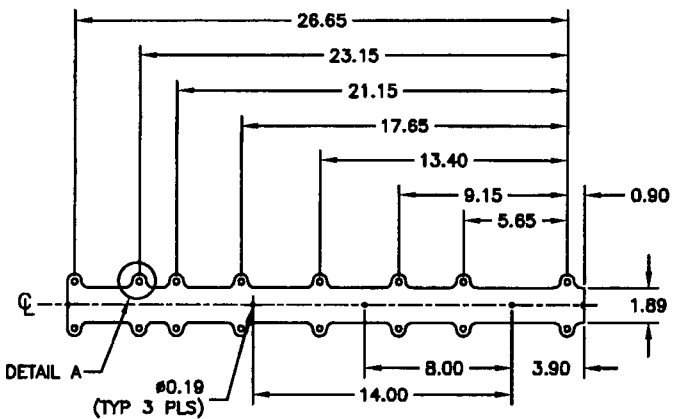
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

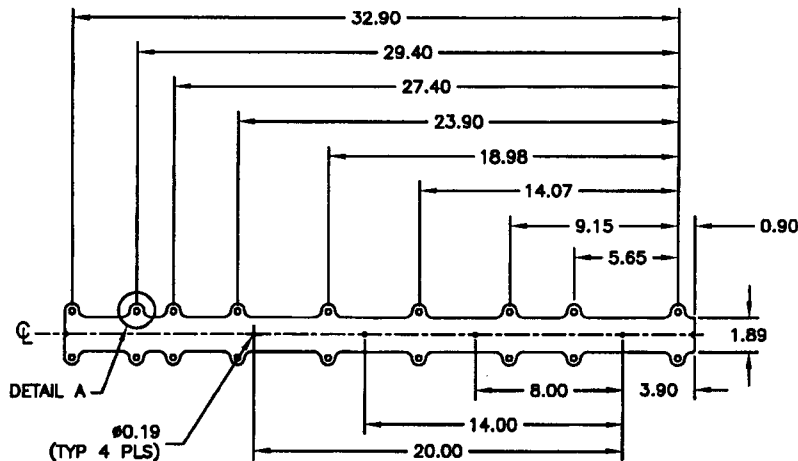
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09.02.12

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE
				1:10



D3536-11 GASKET



D3536-13 GASKET

NOTES

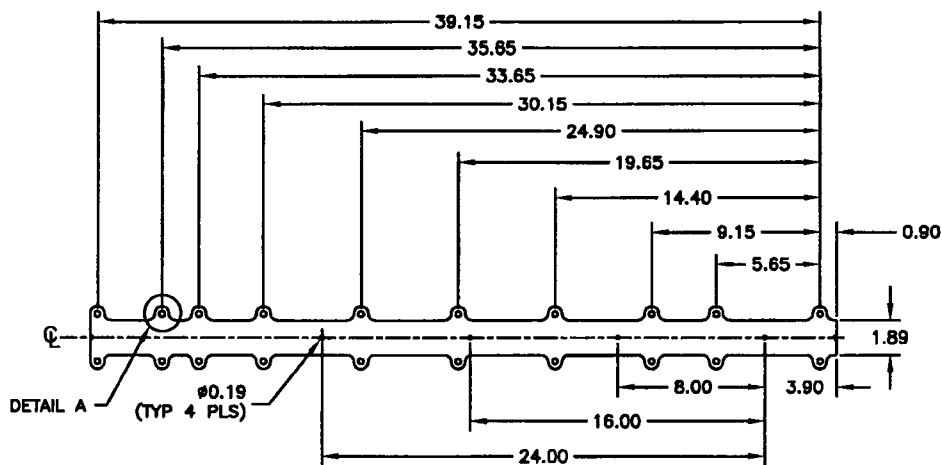
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

51641

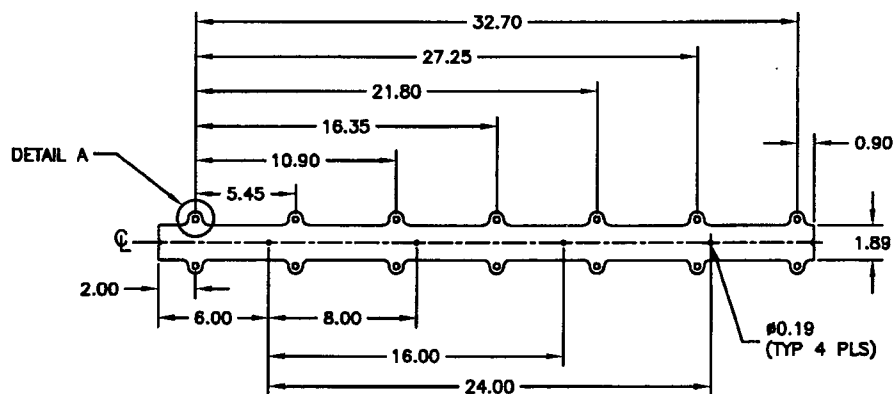
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DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 2 OF 6
		SCALE	1:10	

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07.02.12



D3536-15 GASKET



D3536-21 GASKET

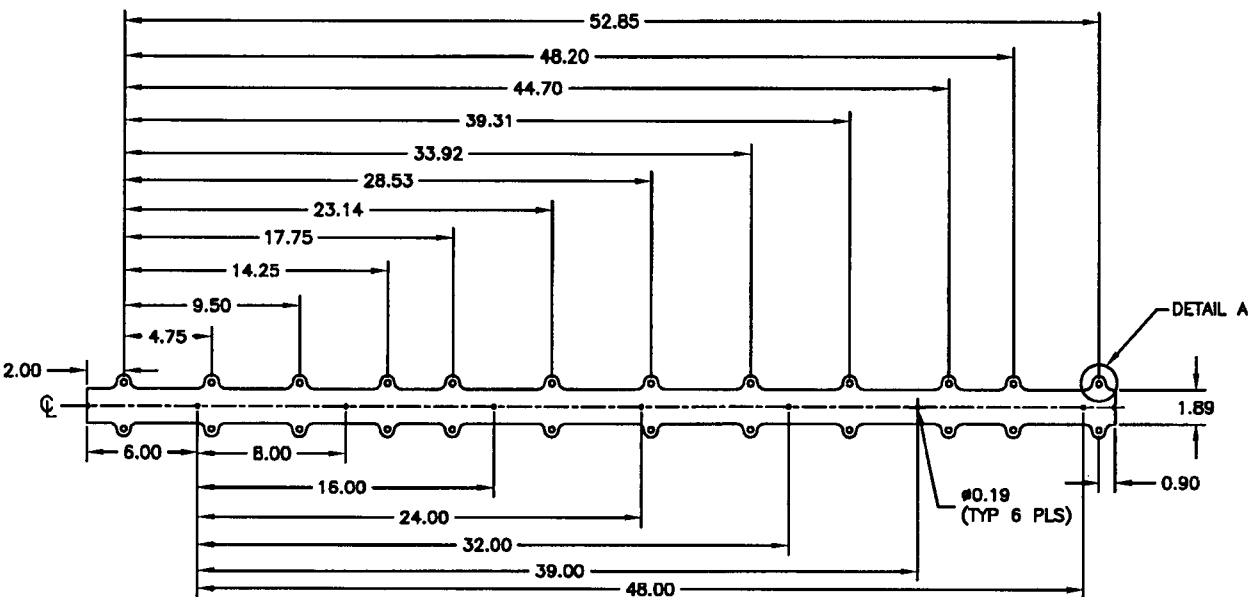
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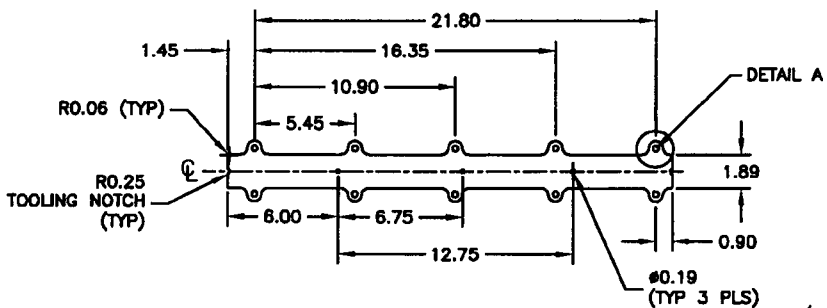
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 3 OF 6
				SCALE
				1:10

RELEASED
070212



D3536-23 GASKET



D3536-25 GASKET

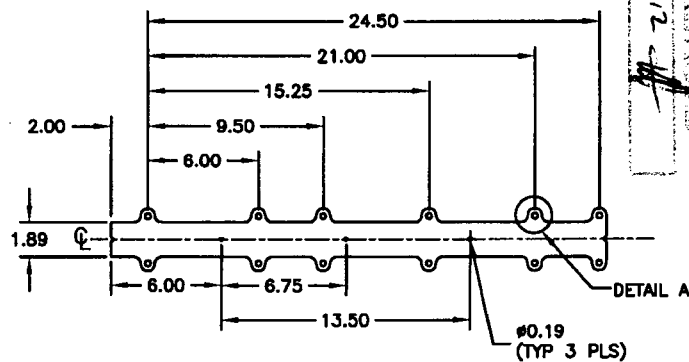
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
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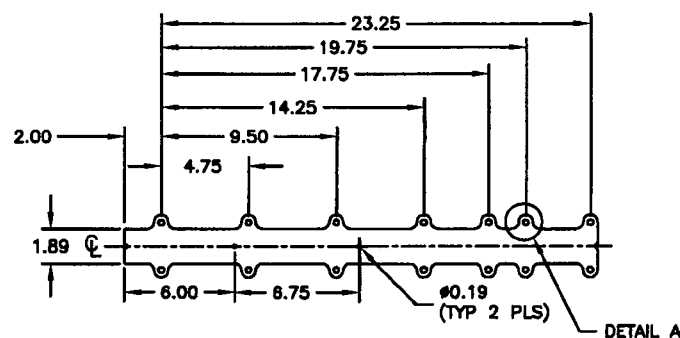
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DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 4 OF 6
		SCALE	1:10	

07.02.12

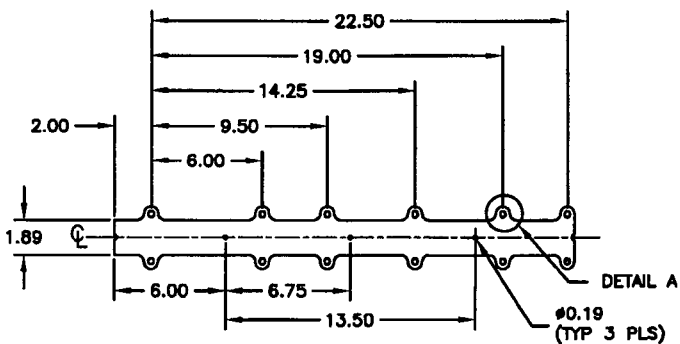


D3536-33 GASKET



D3536-35 GASKET

51641




D3536-31 GASKET

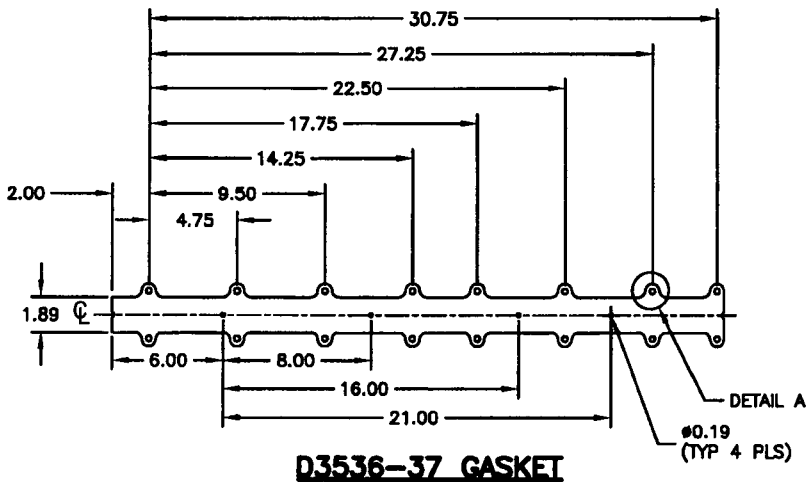
NOTES

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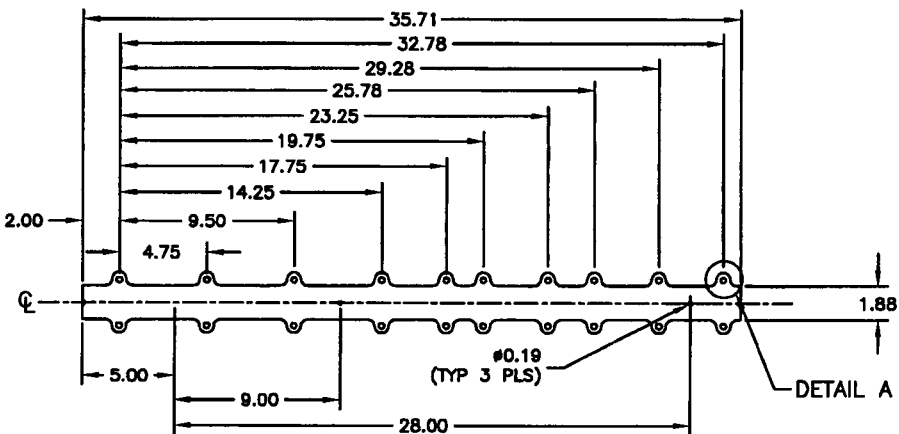
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DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.	
CHECKED	PH	APPROVED		DRAWING NO.	REV. A
DATE	06.10.25			D3536	SHEET 5 OF 6
				TITLE	SCALE
				GASKET	1:10

07.02.02 *St*



D.35.36-37 GASKET



D3536-39 GASKET

51641

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